

Date: Sunday, 12/4/2005 12:44:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 25088		
Estimate Number	: 10271		
P.O. Number	: N/A	Part Number	: D2561
This Issue	: 12/4/2005 S.O. No. : N/A	Drawing Number	: D2561 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 12/10/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	40 Um: Each
Comment	: Est C 00.05.19 Added inspect level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
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Comment: Qty.: 0.3850 f(s)/Unit Total: 15.4014 f(s)
 Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick
 Batch: M17869

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 1-Cut blanks: 8.70"
 Note: 1 blank makes 2 parts

J.L 05.12.16 41

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per folio D2561
 2-Deburr, no sharp edges

J.L 05.12.19 41

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 05.12.19 41

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG

Job Number: 25088

Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 05.12.19

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WAA

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr, no sharp edges

PD 06-01-06

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WAA

PD 06-01-06

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUS 06/01/10

(41)

PD 06/01/09

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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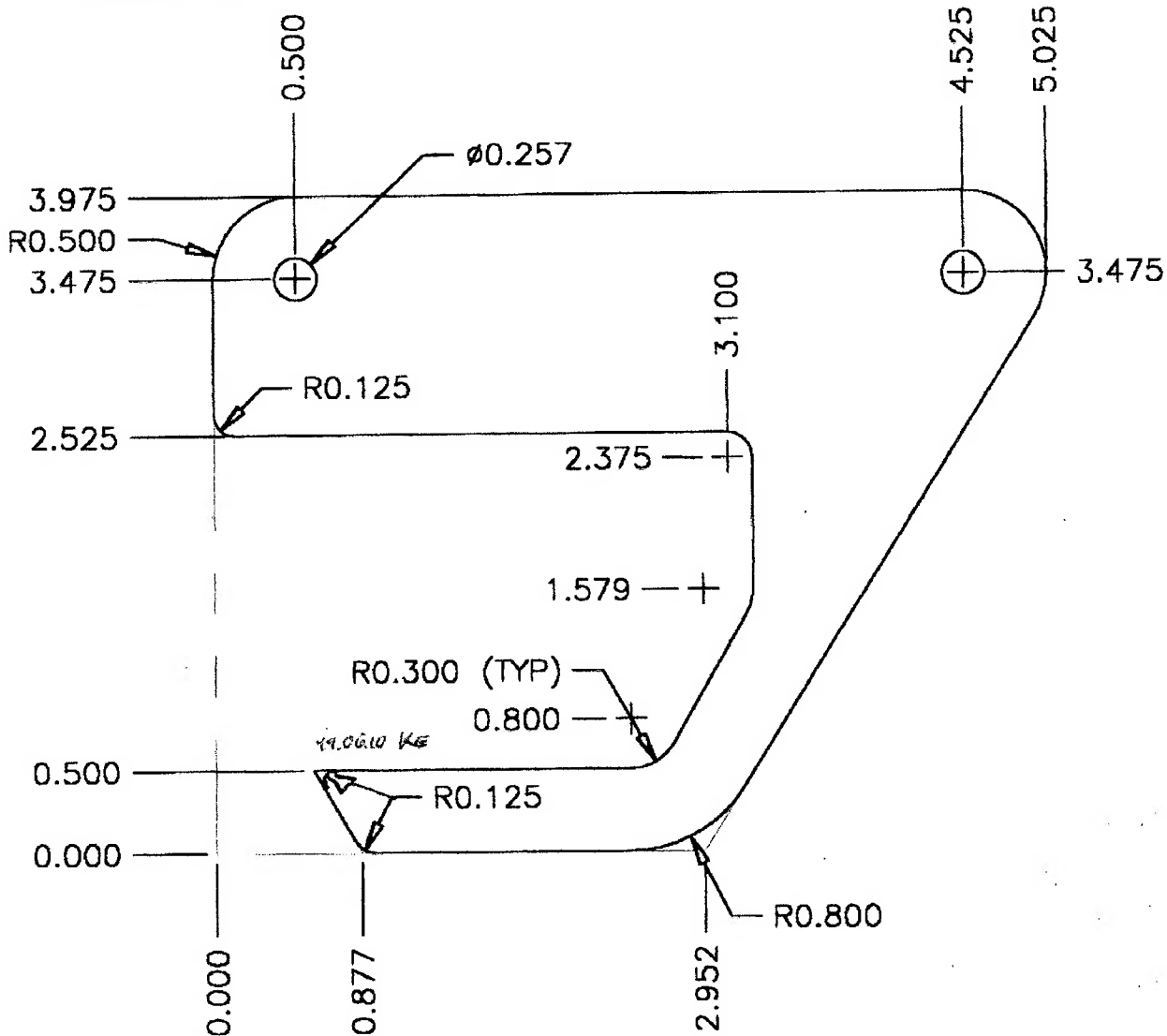
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DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2561	SHEET 1 OF 1
DATE	TITLE	SCALE	
96.04.26	LUG PLATE	1:1	

RELEASED
96 05 06



MATERIAL: 6061-T6 0.25 THICK
OR 6063-T6 0.25 THICK
OR 5052-H34 0.25 THICK

